Work Order Friday, May 27, 2											Page 1
Revision ID:	D3182-1			Accept				s	etup Stai		
		art Qty: 4.00 q'd Qty: 4.00			Cust Item Customer:	ID:			Sto	P    <b>       </b>	
• •	Process Plan:	P	Date: //- 05-2	Tooling: SPC (Y/N):		ate:		R	tun Star Sto		
Sequence ID/ Work Center ID		eration cription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision	Nbr					4.00				4.
D3182	Rev A										
100 Waterjet FLOW CNC Waterjet		OW WATER JET  Memo  1-Cut as per  Deburr if ne	Dwg D3182 □Dwg Rev cessary	0.00 0.00 /: <b>^A</b> □Prog Rev:	<b>A</b> □2-			BILS	- <u>30</u>		<u>t</u> )
110 	QC2	2- Inspect parts off n  Memo	nachine FAI/FAIB	0.00				BIL	<u>5-30</u>		

120

QC

Quality Control

QC8- Inspect parts - second check

Quality Control

Memo

Dart Aerospace	Lta
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W/O:			W	ORK ORDER CH	ANGES					
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									·	
4-1										
Part No	•	PAR #:	Fault Cate	egory:	NC	CR: Yes N	lo <b>DQ</b> /	A:	_ Date: _	
	R	esolution:	Disposition	on:	Q <i>A</i>	A: N/C Clo	sed:		Date: _	
NCR:		\	WORK ORD	ER NON-CONFO	RMANC	E (NCR)				
DATE	STEP	Description of NC		Corrective Action	Section B Verific			ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	lion	Sign & Date	Secti	on C	Chief Eng	QC Inspector
					/					
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NOTE: Date & initial all entries

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Work Orde Friday, May 27,												Page 2
Item ID: Revision ID: Item Name:	D3182-1 Hinge			Accept					Setup	Start Stop		
Start Date: Required Date: Reference:	5/27/2011 6/3/2011	Start Qty: 4.00 Req'd Qty: 4.00	1881   880 1581   1881   881 1881		Cust Item I Customer:	D:						
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):		nte:			Run	Start Stop		
Sequence ID/ Work Center II  130 Small Fab Small Fab  140 QC Quality Control	)	Operation Description  Small Fab  Memo Deburr if ne		Set Up/ Run Hours 0.00 0.00	Tool ID	Tool#	Plan Code	Accep	t Re		Reject Number	Insp. Stamp

150 Packaging

Packaging

Identify as per dwg & Stock Location.

\*\*\*\*\*STOCK IN BASKET CELL\*\*\*\*\*

0.00

Memo

0.00

SAD 11-06-03

## **Dart Aerospace Ltd**

Dail AC	ospace	Liu		i,						
W/O:			WO	RK ORDER CH	NGES	<u> </u>				
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					:					
Part No	:	PAR #:	Fault Categ	jory:	N	ICR: Yes	No DQ	A:	Date: _	
	Re	solution:	Disposition	);	(	A: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFO	RMAN	CE (NCF	<b>R</b> )		· · · · · · · · · · · · · · · · · · ·	
		Description of NC		Corrective Action	Section E	3	Vorifi	cation	Approval	Approval
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date	k Sect	erification Section C Approval Chief Eng		QC inspector
			1			1	r		1	1

Work	Order	ID	70135
1 1 O I II	Oiuci		70100

Friday, May 27, 2011 11:39:43 AM



Page 3

Item ID:

D3182-1

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Hinge

QC:

**Start Date:** 

Required Date: 6/3/2011

5/27/2011

Start Qty: 4.00

Req'd Qty: 4.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date: Date: Tooling: SPC (Y/N):

Date: Date: Run

Start



Stop

Sequence ID/

**Work Center ID** 

160

Quality Control

**Operation** Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/ Run Hours

0.00

0.00

**Tool ID** 

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number,

Insp. Stamp

MF -06-03

# **Dart Aerospace Ltd**

W/O:

W/O:			WORK ORDER	CHANGES					
DATE	STEP	PF	ROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
						·			
Part No	:	PAR #:	Fault Category:	NC	R: Yes	No <b>DQ</b>	A:	Date: _	
	Resolutio	n:	Disposition:	QA	: N/C (	Closed:		Date: _	

NCR:	WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action	Section B		Verification	Approval	Annewal		
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		ion	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
						·					
							:				

# **Picklist Print**

Friday, May 27, 2011 11:39:49 AM

Work Order ID: 70135

Parent Item: D31

D3182-1

Parent Item Name: Hinge



Start Date: 5/27/2011

Required Date: 6/3/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP □A□03.01.29□New issue□KJ/RF□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304\$11GA		Purchased	No			100	sf	136.7000	0.0596	0.250947		,··	
										æ	UI -4-3	34	

304/316 0.125 Sheet

 Location
 Loc Oty
 Loc Code

 MAT020
 136.7

 117494
 136.7

117494

4

## **Dart Aerospace Ltd**

Dail Ac	ospace	Llu								
W/O:			WO	RK ORDER CH	NGES				·· · · · · · · · · · · · · · · · · · ·	· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	OCEDURE CHAN	IGE	By Date Qty				Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	\	ICR: Yes	No DQ	A:	Date:	
	Re	solution:	Disposition	):	0	A: N/C CI	osed:		Date: _	
NCR:			WORK ORDE	R NON-CONFO	RMAN	CE (NCF	<b>R)</b> .			
D.4.T.E		Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign 8 Date		ion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	1013 5
Description: Hinge	Part Number:	D3182-1
Inspection Dwg: D3182 Rev: A		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
3.718	+/-0.010	3.787	3		U1802						
Ø0.257	+0.006/-0.001	-)XD	8		U						
2.304	+/-0.010	2307	۶		V						
R0.125	+/-0.010	.174	3	-	K.G.						

Measured by:	B	Audited by:	Prototype Appro	oval:	N/A
Date:	11-5-35	Date: 11/05/34	D	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.10.12	New Issue	KJ/JLM	
В	08.01.16	3.718 was 3.178	KJ/EC/DD	77

<b>Dart</b>	<b>Aero</b>	space	Ltd

<b>-</b> u	Johnson	Liu									
W/O:				٧	ORK ORDER CHANGES						
DATE	STEP	PF	ROCEDUF	E CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
										Pate:	
						-					
Part No: PAR #:		Fau	It Ca	tegory: NC	NCR: Yes No DQA: Date:						
Resolution: Dis			posit	ion: Q <i>A</i>	NC C	/C Closed: Date:					
NCR:			WORK	OR	DER NON-CONFORMANC	E (NCI	R)				
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Section C		1 Approval	Approval		
DAIL	O.L.	Section A	Init Chief	i <b>al</b> Eng	Action Description Chief Eng	Sign		ion C	Chief Eng	de:	QC Inspector
			:				3				
	-										
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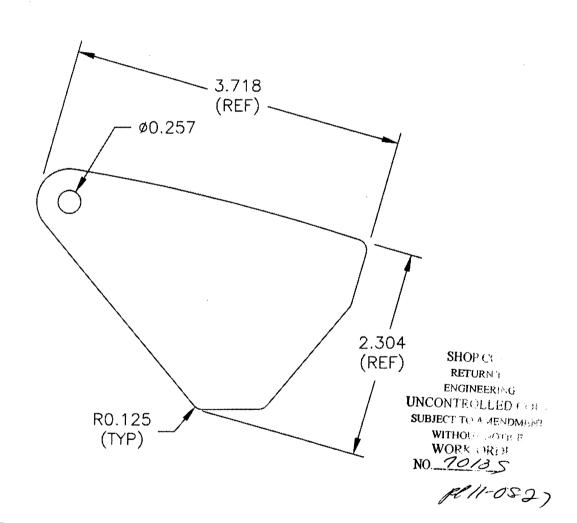
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)	DESIGN -	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
/	CHECKED	APPROVED	DRAWING NO.	REV. A				
	#	d	D3182 SHEET	1 OF 1				
	DATE	······································	TITLE	SCALE				
	03.01.21		HINGE	1:1				
	A	03.01.21	NEW ISSUE					





#### D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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Dart Ae	rospace	e Ltd							
W/O:			1	WORK ORDER CHANGES					
DATE	STEP	PROCEDI	JRE C	E CHANGE By		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							* 4		
				and p		·			
Part No		PAR #: F	ault C	ategory: NC	R: Yes	No DQ			
	R	esolution: D	ispos	ition: QA	: N/C C	closed:		Date: _	
NCR:		WOR	K OF	RDER NON-CONFORMANCI	E (NC	R)			
DATE	STEP		<b>nitial</b> nief Eng	Corrective Action Section B  Action Description Chief Eng	Sign Date	& Sect	<b>cation</b> ion C	Approval Chief Eng	Approval QC Inspector

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